



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBST2812-P-1
Job Sheet 182151



JS #1
9-06

OK, O/S

Part No: RBST2812-P-1

Job Qty: 6 ea
DAS 21
10 ea 9-89

Part Name: Base



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/19/18

Job Tracking No:

Due Date: 8/30/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBST2800-P Rev. 1 IPP Rev. A 18.06.21 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		8/30/18	0.00	0.00	Start Up Machining-3		18/10/24
110	Mori Seiki	6 pcs		8/30/18	0.00	1.50	MORI SL-154		18/10/24
120	QC	6 pcs		8/30/18	0.00	0.00	QC2 Machining-4		18/10/24
130	QC	6 pcs		8/30/18	0.00	0.00	QC8 Machining-4		18-10-26
132	Outsource	6 pcs		8/30/18			MEI001-VC (Atlantic)		CC18-11-1
140	Outsource	6 pcs		8/30/18	0.00	0.00	Outsource12		
150	Packaging	6 pcs		8/30/18	0.00	0.00	Packaging2		NOV 10 2018
160	QC	6 pcs		8/30/18	0.00	0.00	QC6		
210	Packaging	6 pcs		8/30/18	0.00	0.00	Packaging3-1		
220	QC21-SA	6 Ea		8/30/18	0.00	0.00	QC21		NOV 12 2018

Part Op 110 - 1-Machine as per DWG. FC 337 FOLIO REV: _____ DWG REV: _____ 2-Debur
 Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 132 - 1--Issue P/O to Metcore; P/O _____ RC55-60 2-Bead blast ***NOTE*** ensure abrasive blasting does not damage the critical surfaces 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech Polish Race Surface Prior to Black Oxide
 140 - -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required

Outsource 132: P0041558

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-O1-R1.375	Tool Steel Round Bar 1.375 dia.	.5880 ft (.098 ea)	90-Start up Operation	5048887

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-O1-R1.375	1	2	0

Part Specifications

Specifications could not be found.

Plex 9/6/18 8:48 AM dart.logan.david

Atlantic



Container No: S121008



Part: RBST2812-P-1

Job No: 182151

Serial No/Batch: S121008

Revision: 1

Inspector:

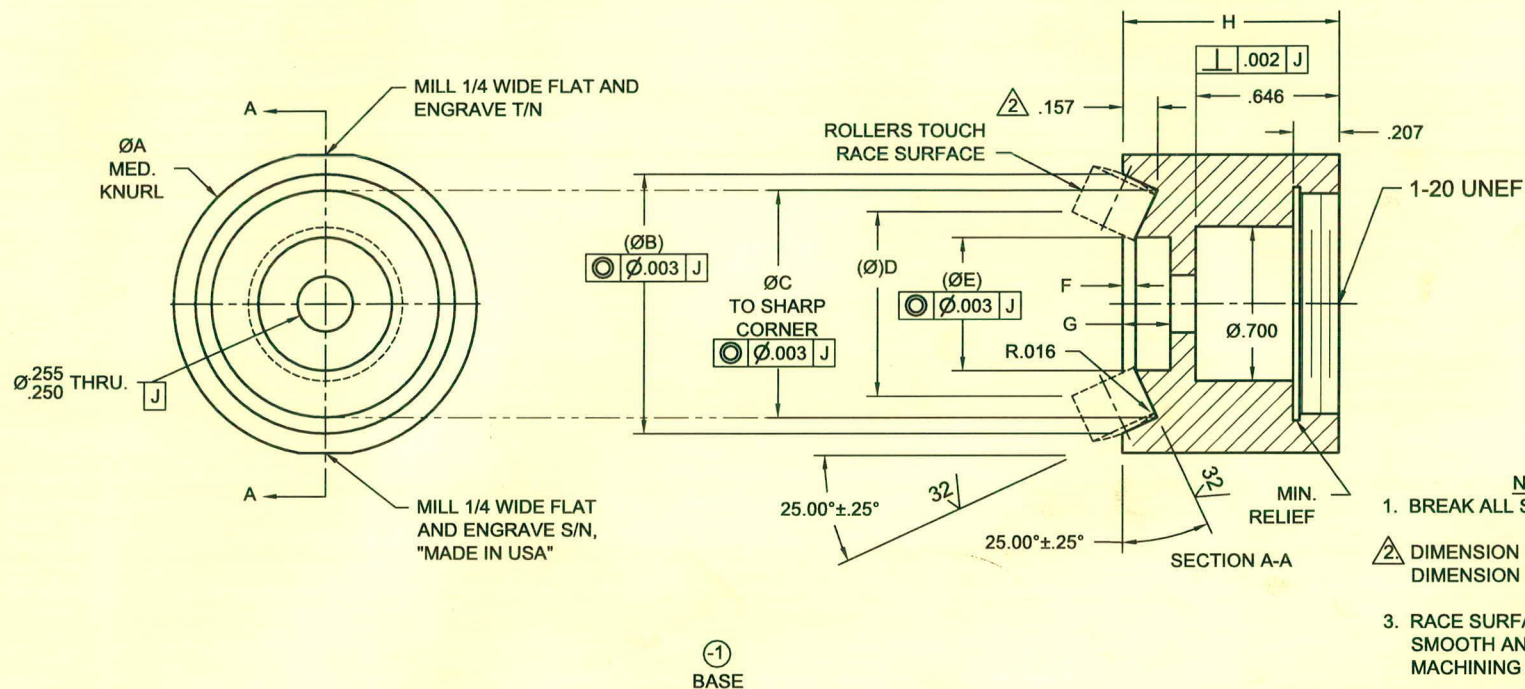
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/10/18

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	CH'D -1 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES.	7/26/12	RJC SE



NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).
2. DIMENSION TO BOTTOM OF R.016=.153; DIMENSION TO SHARP CORNER=.158.
3. RACE SURFACE OF -1 BASE MUST BE SMOOTH AND FREE OF GROOVES & MACHINING MARKS.
4. MUST HOLD ØC POSITION AND ANGLE TOLERANCES TO MAINTAIN PITCH DIA..
5. DO FIRST ARTICLE INSPECTION BEFORE HEAT TREATING.

TOOL #	ØA +.000 -.020	ØB +.006 -.002	ØC +.006 -.002	ØD P.D. REF.	ØE +.006 -.002	F +.003 -.003	G +.005 -.005	H +.010 -.010	MATERIAL
RBST2812-P	1.375	1.177	1.031	.837	.605	.058	.215	.975	O-1 DRILL ROD Ø1-3/8 x 1-1/8

RED BARN MACHINE	
TITLE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL	
DWG NO. TOOL#(see chart)-1 BASE	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± 5° .XX ± .01 .X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 11-9-09 SHEET 2 of 9
DRAWN BY: PERRITT APPROVED: <i>D. Wed</i> HEAT TREAT: RC 55-60 FINISH: BLACK OXIDE SPEC: USED ON BEARING SEE CHART	



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CANADA
TEL.: 1 613 632-5200
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Container No: S121008



Part: RBST2812-P-1

Job No: 182151

Serial No/Batch: S121008

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 10/24/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041558**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO041558
PO Date: 11/1/18
Due Date: 11/8/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041558**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182151	RBST2812-P-1	1--Issue P/O to Atlantic; P/O RC55-60 2-Bead blast ***NOTE*** ensure abrasive blasting does not damage the critical surfaces 3- Certificate of Conformity is required -***Polish race surface as per note 3 prior to black oxide,*** -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; O1 -Certificate of Conformity is required ***NOTE*** ensure abrasive blasting does not damage the critical surfaces 3- Certificate of Conformity is required	Firmed	-	11/5/18	10 pcs	0 pcs	10 pcs	\$21.45/pcs	\$214.50

10 x NOV 10 2018

DAS
38
9-89

Line Item Note **need asap**



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PURCHASE ORDER **PO041558**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	183465	RB6872882-6	1--Issue P/O to Atlantic; P/O _____ RC 36-40 2-Bead blast 3- Certificate of Conformity is required BLACK OXIDE (RED BARN) -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	11/5/18	7 pcs	0 pcs	7 pcs	\$30.642857/pcs	\$214.50

7 X

NOV 10 2018

Line Item Note * need asap *

Grand Total: \$429.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/6/18 3:34 PM dart.tsimiklis.chrisoula

Shipping Ticket

Sold To: 1448
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Ship To: 157196
DART AEROSPACE LTD.
1270 ABERDEEN ST

HAWKESBURY ON K6A 1K7

Page 1 of 1

Purchase Order Number	Packing List No	Customer Job No	Route	Carrier
041558 ✓				

Quantity	Part No. / Part Name / Part Description	Pounds
✓ 10	PCS MATERIAL O - 1 HEAT TREAT TO 55 - 60 RC SANDBLAST BLACK OXIDE C OF C LIGHT FILMEX PART # RBST2812 ✓ P-1 JOB # 182151 ✓	

Container Type	# Of Containers	Cust Cont Id	Container Type	# Of Containers	Cust Cont Id
BOX	1				

NOTICE: OUR LIABILITY IS LIMITED TO OUR INVOICE CHARGES ONLY

Shipped Complete

Quantity Shipped:

10

Pounds Shipped:

3.00

DAS
38
9-88

DR
B.O
59RC

11-6-18

Order No.: 160076

Shipped Complete

Quantity Shipped:

10.00

Received By:

Date:

Pounds Shipped:

3.00

Sold To: DART AEROSPACE LTD.

Shipped ON: 11/05/2018

Introduction

The purpose of this study is to investigate the effects of various factors on the growth and development of the human body. The study is designed to provide a comprehensive overview of the physical and physiological changes that occur during the process of growth. The research is based on a series of experiments conducted over a period of several years, involving a large number of subjects. The results of the study are presented in the following sections, which are organized into three main parts: a description of the methods used, a presentation of the data, and a discussion of the findings. The first part of the study, which is described in detail in the following sections, is a series of experiments conducted over a period of several years, involving a large number of subjects. The results of the study are presented in the following sections, which are organized into three main parts: a description of the methods used, a presentation of the data, and a discussion of the findings.

The second part of the study, which is described in detail in the following sections, is a series of experiments conducted over a period of several years, involving a large number of subjects. The results of the study are presented in the following sections, which are organized into three main parts: a description of the methods used, a presentation of the data, and a discussion of the findings. The third part of the study, which is described in detail in the following sections, is a series of experiments conducted over a period of several years, involving a large number of subjects. The results of the study are presented in the following sections, which are organized into three main parts: a description of the methods used, a presentation of the data, and a discussion of the findings.

Certification

Date: 11/06/2018

Entry Date: 11/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: 041558 ✓

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 01

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
10	10 PCS MATERIAL O - 1 HEAT TREAT TO 55 - 60 RC SANDBLAST BLACK OXIDE C OF C LIGHT FILMEX PART # RBST2812-P-1 JOB # 182151	3

Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

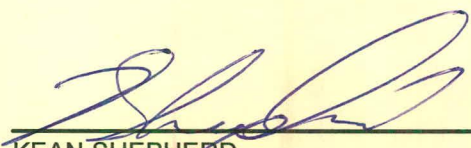
Results:

Harden ROCKWE 55. 60. 59. TESTED AS PER SAMPLING PLAN

HEAT TREATED TO 59 RC AS PER CUSTOMER REQUEST

BLACK OXIDE AS PER CUSTMER REQUEST

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY). ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES), EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER. THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMITS OF LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER, IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE OF CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT. THE AFOREMENTIONED LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortage in weight or count will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for shrinkage, expansion, deformity, or rupture of material in treating or straightening, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given material with detailed instructions as to treatment, our responsibility shall end with the carrying out of those instructions. Failure by a customer to indicate plainly and correctly the kind of material (i.e., proper alloy designation) to be treated, shall cause an extra charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the treater in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the treater. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of treater.

DAS
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KEANE SHEPHERD
QUALITY CONTROL
ATLANTIC HEAT TREATING 2001 LTD

